

Work Order ID 53716

November 13, 2009 9:57:15 AM



Page 1

Item ID: D3594-5

Accept



Setup Start



Revision ID: B

Stop



Item Name: Door Doubler

Start Date: 13/11/2009 Start Qty: 8.00

Cust Item ID:

Required Date: 20/11/2009 Req'd Qty: 8.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

09-11-13

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3594

Rev B

(P18) 7

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3594 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

HB 9-11-18

6061
.000

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

HB 9-11-18

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

2) Sorulug

center
(23)

(5)

9/509/11/9 (23) (18)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3594-5 PAR #: _____ Fault Category: Small Sub/tw. J NCR: (Yes) No DQA: / Date: 05-11-24
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: / Date: 05-11-24

NCR: <u>53716</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>5/11/24</u>	<u>#100</u>	<u>5 Parts Scrap.</u> <u>MOVED DUNNIN WATER JETTING</u> <u>Prod. Dim. 530 is too thin</u> <u>Detail A-2</u> <u>P.L. Process</u>	<u>/</u> <u>05/11/24</u>	<u>Scrap AND Destroy Qty x5</u> <u>Replace m+ <u>109184</u> +20</u>	<u>JB</u> <u>9-11-19</u>	<u>S</u> <u>07/11/19</u>	<u>/</u> <u>05/11/24</u>	<u>S</u> <u>07/11/18</u>

NOTE: Date & initial all entries

Work Order ID 53716

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Page 2

Item ID:	D3594-5	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Door Doubler					
Start Date:	13/11/2009	Start Qty: 8.00		Cust Item ID:		
Required Date:	20/11/2009	Req'd Qty: 8.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1-C'SINK AS [PER dwg d3594								
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
150 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

Handwritten signature 23

⇒ Sostulir

X23

⇒ Hl 09/11/20

X23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53716

Page 3

November 13, 2009 9:57:16 AM

Item ID: D3594-5

Accept



Setup Start



Revision ID: B

Stop



Item Name: Door Doubler

Start Date: 13/11/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 20/11/2009 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

PC 9/11/20 (23)

170

Identify as per dwg & Stock Location: 234 0.00



Packaging

Memo

0.00

Packaging

PC 9/11/20 (23)

180

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

09/11/24
09-11-20
(23)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 13, 2009 9:57:22 AM

Page 1

Work Order ID: 53716

Parent Item: D3594-5RevB

Parent Item Name: Door Doubler



Comments:

Start Date: 13/11/2009

Required Date: 20/11/2009

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	194.4599	0.4632	15790		
<div>   </div>												
6061-T6 .080 Sheet												

189-11-0

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	194.45987	
107904	0.02	
110254	1.5	
110630	38.0926	
112040	0.0437	
112141	9	
112512	0.2784	
112763	145.52517	

109 184

109184X

110630

18

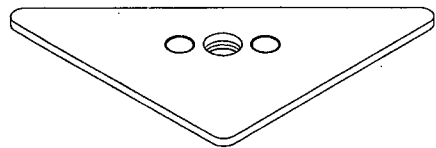
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

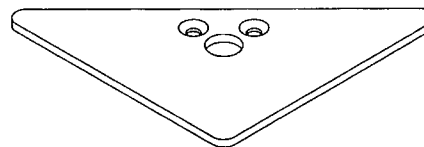
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

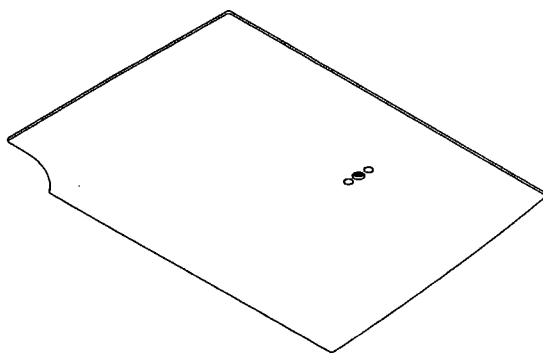
NOTE: Date & initial all entries



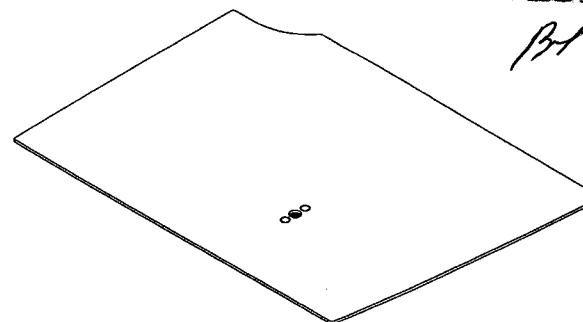
D3594-041 DOOR DOUBLER ASSEMBLY



D3594-5 DOOR DOUBLER



D3594-043 FLOOR DOUBLER ASSEMBLY



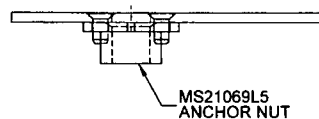
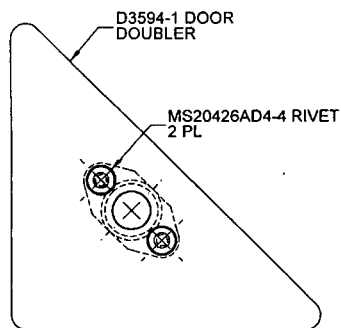
D3594-044 FLOOR DOUBLER ASSEMBLY

SHOP COPY
RETURNED
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO A LATER
WITHOUT NOTICE
WORK ORDER
NO. 53716
BT 08-11-13

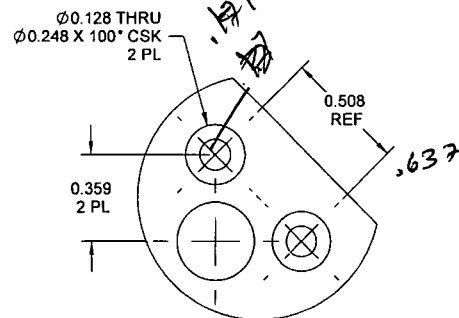
RELEASED
08.05.14

B	REFORMAT TO B SIZE DRAWING. SHEET 2 ADD -5.		AJS	08.05.14
A	NEW ISSUE		MB	07.04.13
REV.	DESCRIPTION		BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3594 REV. B TITLE DOUBLER SCALE NTS		
DRAWN	AJS			
CHECKED	<i>[Signature]</i>			
MFG. APPR.	<i>[Signature]</i>			
APPROVED	<i>[Signature]</i>			
DE APPR.	<i>[Signature]</i>	DATE 08.05.14 <small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>		

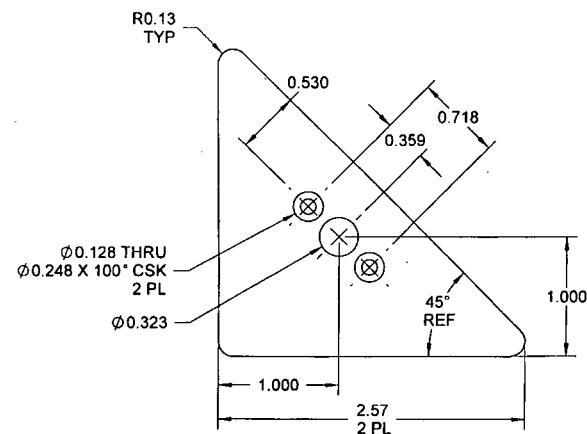
QTY. -041	PART NUMBER	DESCRIPTION
X	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-1	DOOR DOUBLER
1	MS21069L5	ANCHOR NUT
2	MS20426AD4-4	RIVET, CSK



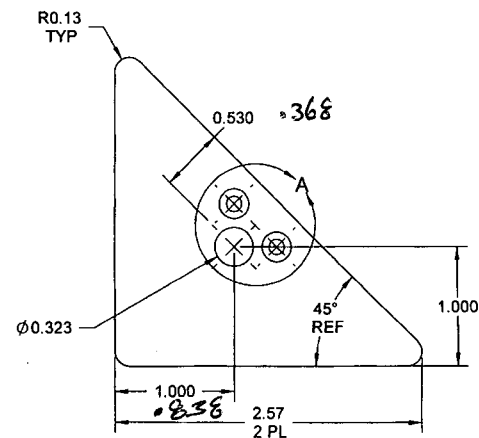
4 D3594-041 DOOR DOUBLER ASSEMBLY



DETAIL A
SCALE 2X



D3594-1 DOOR DOUBLER



5 D3594-5 DOOR DOUBLER

NOTES:

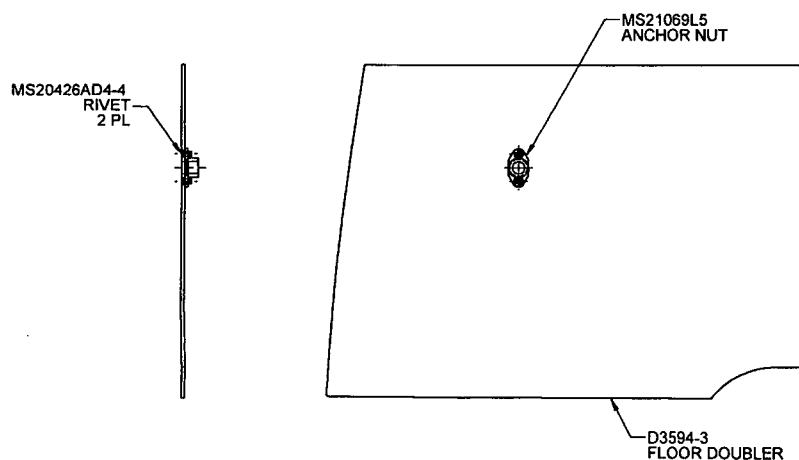
- 1) MATERIAL: -1 & -5
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
- 5) IDENTIFY WITH DART P/N "D3594-5" USING FINE POINT PERMANENT INK MARKER
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -041: 0.04 lbs
-5: 0.03 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AUS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3594	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	08.05.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

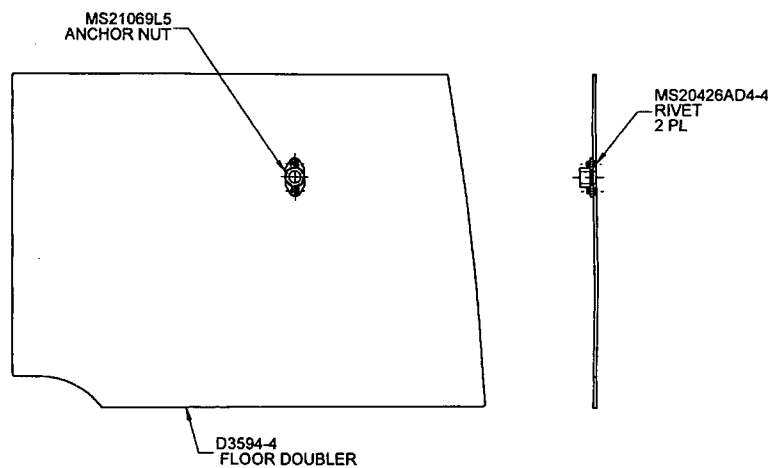
RELEASED
08 06 26 14

4/10 53 716

QTY. -043	QTY. -044	PART NUMBER	DESCRIPTION
X		D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	X	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
1		D3594-3	FLOOR DOUBLER, LH
	1	D3594-4	FLOOR DOUBLER, RH
1	1	MS21069L5	ANCHOR NUT
2	2	MS20426AD4-4	RIVET, CSK



D3594-043 FLOOR DOUBLER ASSEMBLY



D3594-044 FLOOR DOUBLER ASSEMBLY

NOTES:

- 1) MATERIAL: -3 & -4
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -043 & -044: 0.80 lbs

RELEASED
108-06-26-14

w/lo 53716

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3594	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
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